

5/29

DART AEROSPACE LTD	Work Order:	23798
Description: Saddle billet	Part Number:	D6101-013
Drawing: D6101 Rev. A	Qty:	30

Step	Location	Procedure	By	Date	qty
1	EXPEDITING	Open W/O	AF	05.07.14	30
2	PURCHASING	Issue P/O: <u>2008370</u> a) Description: Alluminum billet b) 10.100" x 8.250" x 2.50" thick (+0.030 / -0.000) c) Tolerance on all dimensions are +0.030/-0.000" d) Grain direction along 10.100" length e) Material: 7075-T7351 (QQ-A-250/12) Material certification required	W	05.07.15	30
3	RECEIVING	Receive & Inspect for transit damage Ensure certification are attached	CL	05/09/02	30
4	QC	Inspect level 6 Check certification to Dwg D6101 for compliance	en	05/09/14	30
5	STORES	Identify & stock	CL	05/09/02	30
6	EXPEDITING	Close W/O Cost / part <u>147.94</u> <u>545</u> <u>05/09/15</u> <u>Level 21</u> <u>148.51</u>	AF	05/09/12	30

Rev	Date	Change	Revised By	Approved
A	01.05.04	New Issue	EC	EC

RELEASED

01.05.16

RF
03.06.05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ES Date: 25/09/19

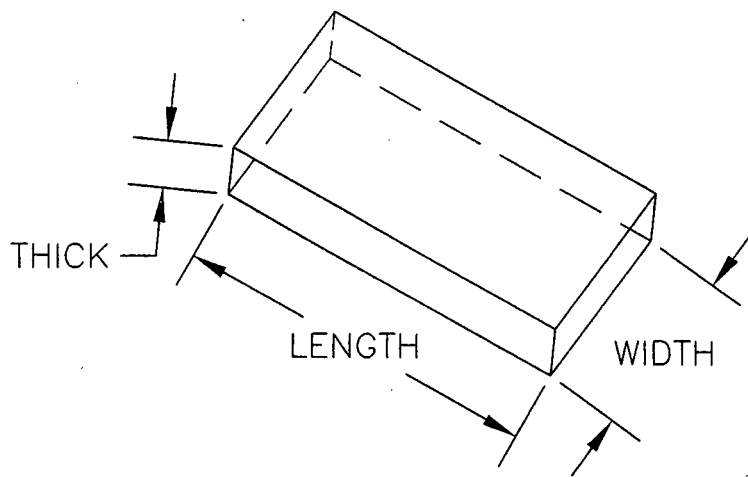
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>S</i>	DRAWING NO. D6101	Rev. A SHEET 1 OF 1
DATE 01.03.30		TITLE SADDLE BILLET, 7075	SCALE NTS
A	01.03.30	NEW ISSUE	

SPECIFICATION CONTROL DRAWING



RELEASED
01.04.23 *CP*

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 23798

PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, LENGTH x WIDTH x THICK (+0.030/-0.000), AND GRAIN DIRECTION AS SHOWN.

TOLERANCES ON ALL DIMENSIONS ARE +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES.

Part No.	Alloy	Length	Width	Thick	Grain Direction
D6101-001	7075-T7351 (QQ-A-250/12)	6.000	6.250	2.000	Along 6.000 Length
D6101-003	7075-T7351 (QQ-A-250/12)	7.875	6.250	2.000	Along 7.875 Length
D6101-005	7075-T7351 (QQ-A-250/12)	5.000	8.250	2.500	Along 5.000 Length
D6101-007	7075-T7351 (QQ-A-250/12)	7.750	8.250	2.500	Along 7.750 Length
D6101-009	7075-T7351 (QQ-A-250/12)	8.700	8.250	2.500	Along 8.700 Length
D6101-011	7075-T7351 (QQ-A-250/12)	9.700	8.250	2.500	Along 9.700 Length
D6101-013	7075-T7351 (QQ-A-250/12)	10.100	8.250	2.500	Along 10.10 Length

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Jul 14, 2005
01:31 pm

Work Order No : 0023798
Project Name : D6101-013
Project For : WK529
Work Order Type : Main
Main WO Number :
House Part Number : D6101-013
Description : Saddle billet
Manufactured : Yes
Amount Req'd : 30
Amount Done : 0
Start Date : 07-14-05
Est Finish Date : 07-30-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

CERTIFIED INSPECTION REPORT

Alcoa Inc.

PITTSBURGH, PA DAVENPORT WORKS

Ship From: RIVERDALE, IA.

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet, the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.

Mark J. Vrabec

Mark J. Vrabec
Director of Manufacturing Davenport Works

Kenton P. Young

Kenton P. Young
Quality Assurance Manager

477706

Ship Date

2005-08-23

P.O. No./Govt Contract No.

CE4624

234035

B.L. No.

82128

Invoice No.

29317

Customer

C&B-WALLINGFORD

Alcoa No. Item

DS-87314-1

Page 1

Ship To: COPPER & BRASS SALES INC
WALLINGFORD BRANCH
5 STERLING DRIVE
WALLINGFORD, CT 06492

Item Description

2.500 IN TK X 48.5 IN W X 144.5 IN LN (N) A/T 7075-
T7351 RECTANGLE MILL FINISH, USI 3MM DEAD ZONE REQ'D BOTH SIDES,
SAWED {{ P/N 091557-9 }}. PER AMS-QQ-A-250/12 & EXCEPT MARKING AMS-
STD-2154 & EXCEPT MARKING MMS159-REV N &
EXCEPT MARKING ASTMB209 REV 04 & EXCEPT
MARKING BSS7055 REV A & EXCEPT MARKING
AMS4078 REV F ((MARKED)) INTERLEAVED
MAX GROSS SKID WGT: 5000 LB QUAN TOL +/-
40 % USI CL A 3 MM CQR 0147255 REV 04 CUST REQ 05-08-
07 *** W/E 05-08-13 ***

Num	Package Ticket	Lot	Weight	Quantity	UOM	Pc Id/Serl
1	319222	468181	3580	2	PC	
2	319223	468181	3580	2	PC	
			7160	4		

Notes for CQR: 0147255.4

THIS MATERIAL HAS BEEN ULTRASONICALLY INSPECTED FULLY IMMERSION - TYPE I.
PRODUCT PRODUCED TO THE REQUIREMENTS OF MIL-STD-2154 ALSO MEET THE REQUIREMENTS OF AMS-STD-2154. PRODUCT PRODUCED TO THE
REQUIREMENTS OF AMS-STD-2154 ALSO MEET THE REQUIREMENTS OF MIL-STD-2154.
PRODUCT PRODUCED AND MARKED TO THE REQUIREMENTS OF AMS-QQ-A-250/12 ALSO MEETS THE REQUIREMENTS OF QQ-A-250/12F. PRODUCT
PRODUCED AND MARKED TO THE REQUIREMENTS OF QQ-A-250/12F ALSO MEETS THE REQUIREMENTS OF AMS-QQ-A-250/12.

CQR: 0147255.4 -Specification Limits

Temp	Dir	UTS	TYS	EL4D
		KSI	KSI	PCT
T7351	Long Transv.	Max	63.9	
		Min	66.0	6
T7351	Elec. Cond. (EC)	% MIN	38.0	PCT

Chemical Composition	SI	FE	CU	MN	MG	CR	ZN	TI	Other Each	Other Total	Aluminum
Alloy 7075	Max	.40	.50	2.0	.30	2.9	.28	6.1	.20	.05	.15
	Min			1.2		2.1	.18	5.1			REMAIN

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Per:

Mark J. Vrabec

Mark J. Vrabec
Director of Manufacturing Davenport Works

Kenton P. Young

Kenton P. Young
Quality Assurance Manager

477706

234035

Ship Date

B.L. No.

Invoice No.

Alcoa No. Item

Page 2

2005-08-23

82128

29317

DS-87314-1

P.O. No./Govt Contract No.

Customer

CE4624

C&B-WALLINGFORD

Lot: 468181 -Mechanical, Physical, Metallography, Quantometer Results -----

Temp	Dir	No.	UTS	TYS	EL4D
		Test	KSI	KSI	PCT
T7351	Long Transv.	3	Max 72.3	61.4	11.1
			Min 70.9	59.8	10.3
T7351	Elect Cond %IACS	40.6 40.7 40.7	PCT		

Cast Number	Chemical	SI	FE	CU	MN	MG	CR	ZN	TI
H9794012	Actuals	.06	.30	1.6	.02	2.6	.19	5.8	.02